Process Sheet

CU-DAR001 Dart Helicopters Services Customer

25556B 10279 Job Number

Estimate Number

P.O. Number This Issue

Previous Run

Comment

MIA 1/18/2006

S.O. No. : NIA

NC Prsht Rev. NIA First Issue

Type

: 25455

: MACHINED PARTS

Part Number Drawing Number

Drawing Name

: D3121143 : D3121 REV C2

: BRACKET ASSEMBLY

: N/A **Project Number** : C2 **Drawing Revision** :NIA Material

Due Date

Each

Written By Checked & Approved By : SEE COMMENTBELOW

: SAR ABOVE DATE & USER : Est Rev:Pick:A 04.02.18 New issue KJ/DS

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0



17-4 SS Bar



Comment: Qty.:

0.3864 f(s)/Unit Total: 1.5456 f(s)

Material: 17-4 SS Bar per AMS 5604/5643

(M17-4-B1.000x02.000) Identify for D3121-113 Batch: <u>M19712</u>

2.0

BAND SAW

BAND SAW





Comment: BAND SAW

Cut blanks: (1.000" x 2.000") 4.425" long

06.02.16

3.0

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-11 as per Folio FA330 and Dwg D3121 Identify as D3121-113

2-Deburr

3-Scribe batch number

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4

Dart Aerospace Ltd

PROCEDURE CHANGE			\top		
	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·					

QA: N/C Closed: ____ Date: ___

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section E		Verification		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
•								
		4.2						
		•						
				·				
				•				

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:04:40 PM Kim Johnston **Process Sheet** User: **Drawing Name: BRACKET ASSEMBLY** Customer: CU-DAR001 Dart Helicopters Services Job Number: 25556B Part Number: D3121143 Job Number Seq.'#: * Description: **Machine Or Operation:** SECOND CHECK 35.0 Comment: SECOND CHECK 36 ч Bolt D312121 6.0 2.0000 Each(s)/Unit Total: 8.0000 Each(s) Comment: Qty.: Pick: Description Batch **Qty Part Number** Bolt 1825454 2 D3121-21 D3121241 Bearing Assembly 7.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s) Pick: **Qty Part Number** Description Batch 2 D3121-241 Bearing Ass 3 255% SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble D3121-143 as per Dwg D3121. INSPECT WORK TO CURRENT STEP 9.0 Comment: INSPECT WORK TO CURRENT STEP 10.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock 57408 Location: DOCUMENT CONTROL 11.0 Comment: DOCUMENT CONTROL Inspection Level 21 N 06.02.23 Job Completion

Form: rprocess

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHA	WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	A :	Date:	

QA: N/C Closed: ____ Date: __

NCR:		CR: WORK ORDER NON-CONFORMANCE (NCR)						
		STED Description of NC		Corrective Action Section B	<u> </u>	Verification	Annessal	Ammanal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

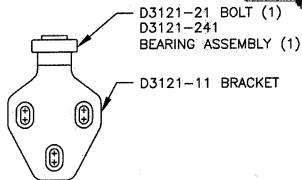




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	DATE		TITLE	SCALE	
-	04.02.17		BRACKET ASSEMBLY	1:2	
	A	02.04.15	NEW ISSUE		
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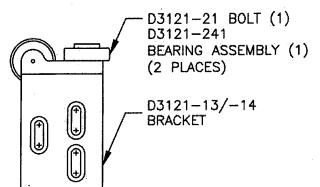
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	04.0	02.17	BRACKET ASSEMBLY 1:2
1	Α	02.04.15	NEW ISSUE
	В	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146
	С	04.02.17	ADD CLEARANCE; USE -241 BEARING
	CI	OF 04.03,26	397 WAS 400; G.II WAS G.14
	CZ	# TF 04.04.26	0.230 WAS 0.238



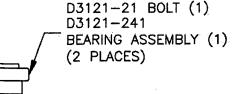
D3121-041 BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (ORPOSITE)
BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-35/-36)

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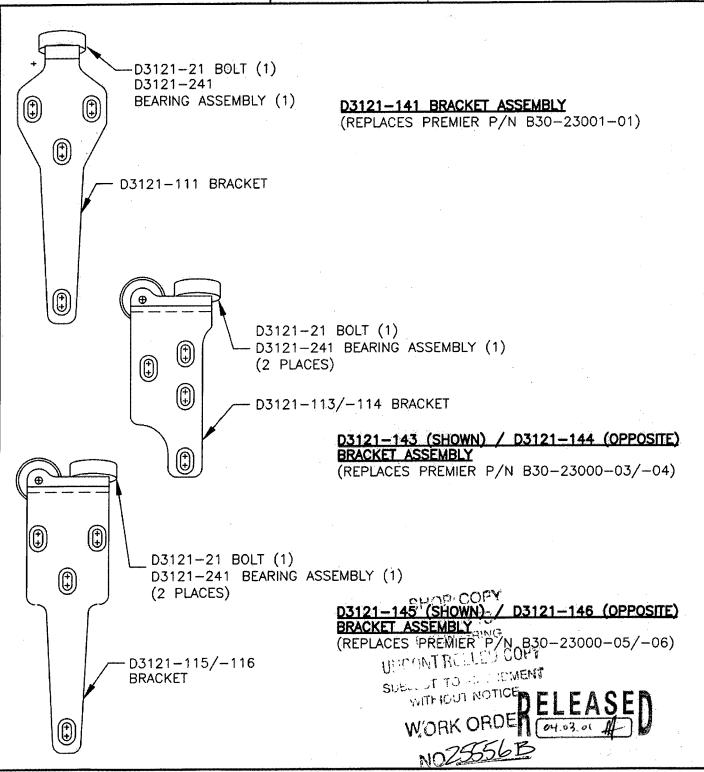
NU. 255661

D3121-15/-16 BRACKET

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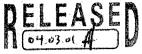
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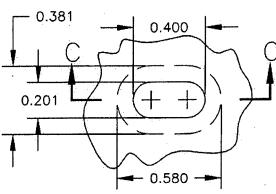


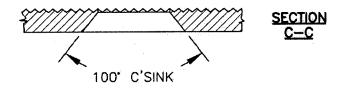


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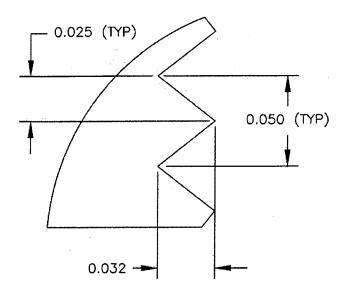


DETAIL A: SLOT DETAIL SCALE 2:1 VIEW ROTATED





DETAIL B: RIDGE DETAIL PARTIAL SECTION SCALE 1:20



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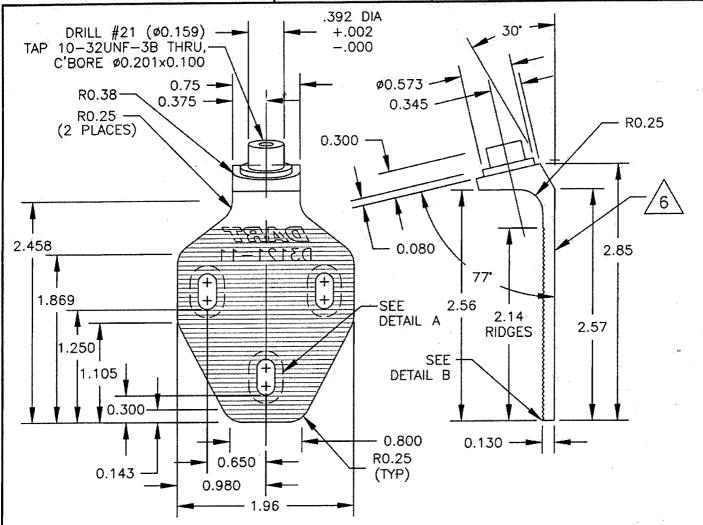
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WORK ORDER





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1	DATE	1	TITLE	SCALE
	04.02.17		BRACKET ASSEMBLY	1:1



D3121-11 BRACKET

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi

MIN YIELD TENSILE = 100 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

BREAK ALL SHARP EDGES 0.005 TO 0.015

5) ENGRAVE DART P/N & LOGO AS SHOWN
6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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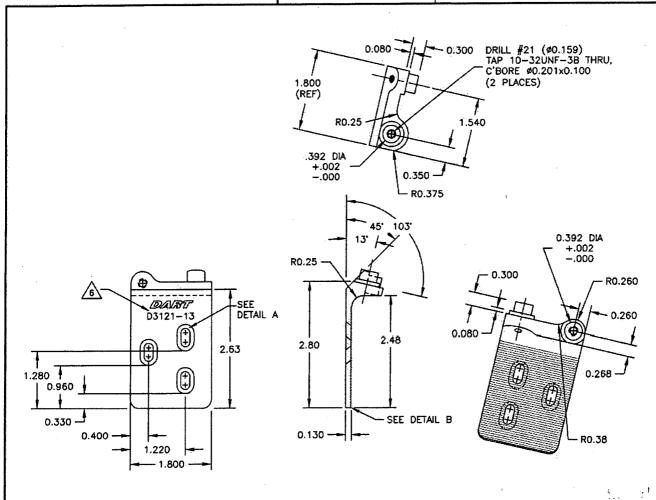
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	A	#	D3121	SHEET 5 OF 10	
-	DATE		TITLE	SCALE	
	04.02.18		BRACKET ASSEMBLY	1:2	



D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

4) BREAK ALL SHARP EDGES 0.005 TO 0.015

5) ENGRAVE DART P/N & LOGO AS SHOWN

6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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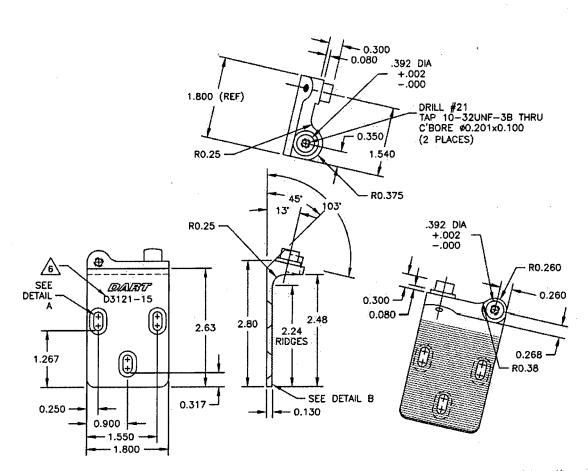


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WORK ORDE

NO. 25556B

MIN YIELD TENSILE = 100 ksi TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

MIN ULTIMATE TENSILE = 150 ksi

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)

ALL DIMENSIONS ARE IN INCHES

D3121-15 BRACKET (SHOWN)

D3121-16 BRACKET (OPPOSITE)

BREAK ALL SHARP EDGES 0.005 TO 0.015

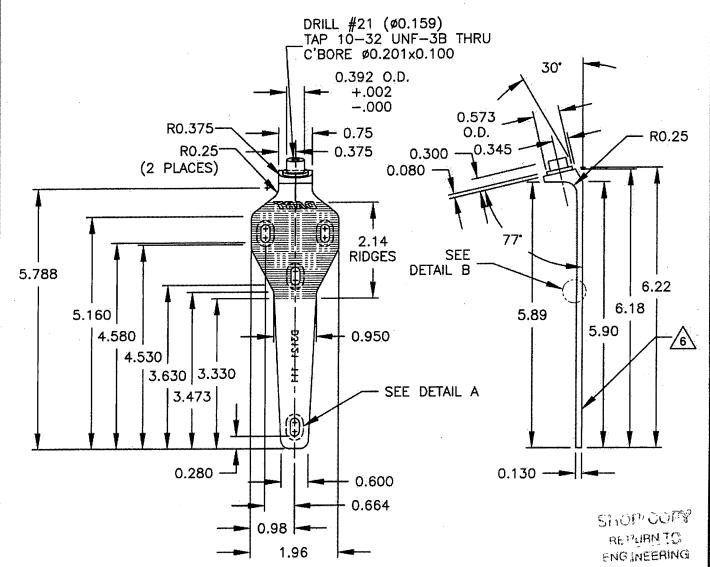
ENGRAVE DART P/N AND LOGO AS SHOWN 5)

6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DATE	_1	TILE	SCALE
04.02.18		BRACKET ASSEMBLY	1:2



D3121-111 BRACKET

1) REPLACES PREMIER P/N B32-23001-11

2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi

MIN YIELD TENSILE = 100 ksi

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED

ALL DIMENSIONS ARE IN INCHES

BREAK ALL SHARP EDGES 0.005 TO 0.015

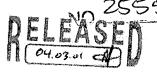
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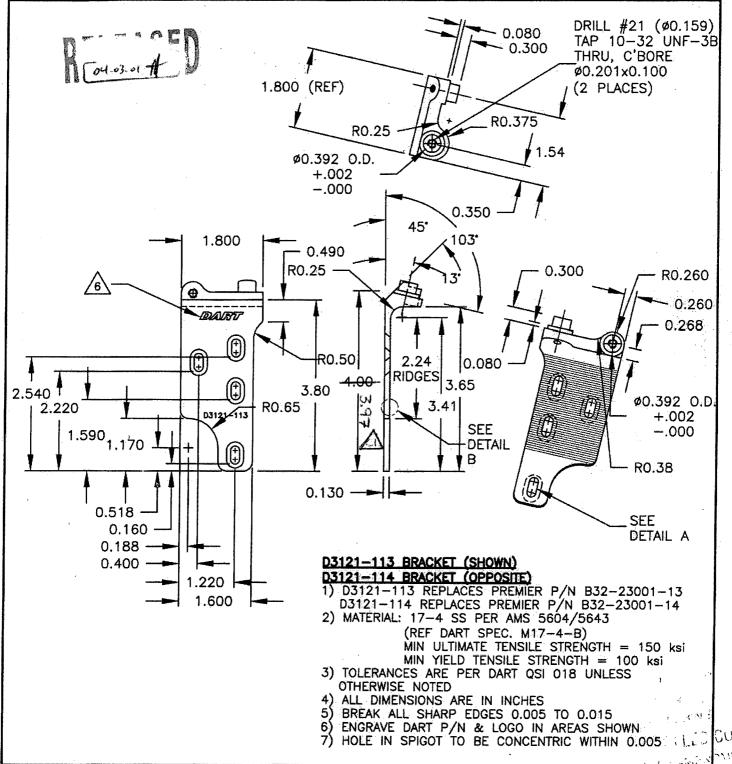
WORK ORDER







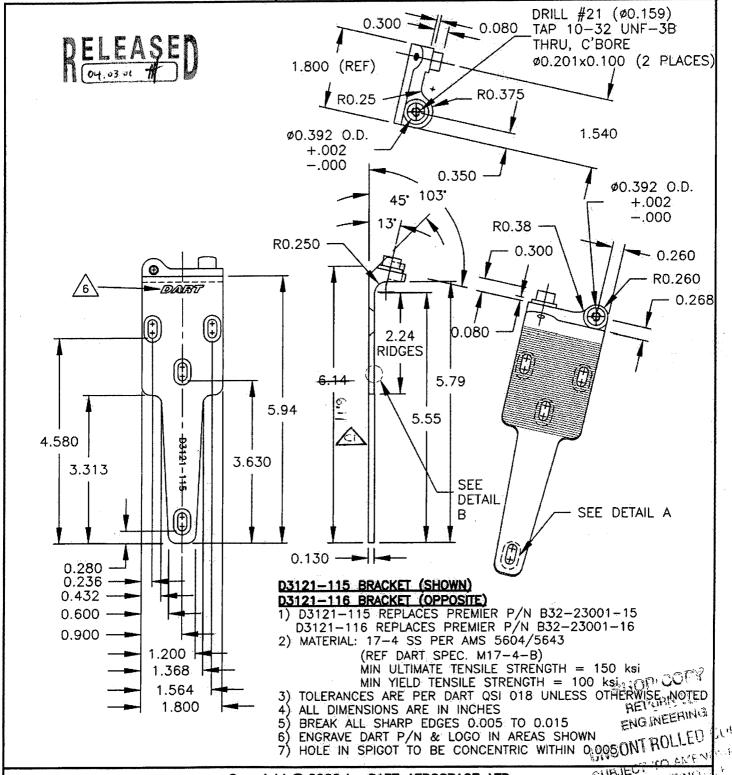
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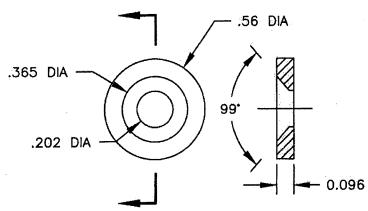
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04.02.17		BRACKET ASSEMBLY	1:1



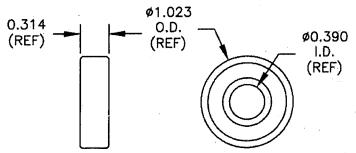
D3121-17 WASHER (SCALE 2:1)

1) REPLACES PREMIER P/N B32-23001-17
2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)

3) TOLERANCÈS ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

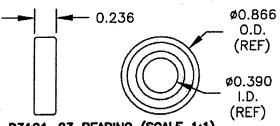
5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-19 BEARING (SCALE 1:1)

1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD

2) ALL DIMENSIONS ARE IN INCHÉS

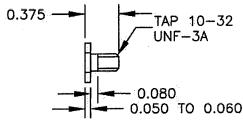


D3121-23 BEARING (SCALE 1:1)

1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ

2) ALL DIMENSIONS ARE IN INCHES

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D3121-21 BOLT (SCALE 1:1)

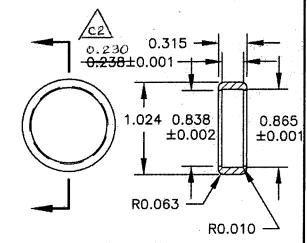
1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)

FINISH: NONE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

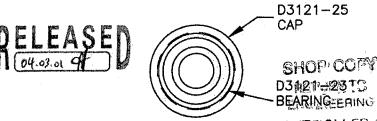
1) MATERIAL: DELRIN ROD, Ø1.25

(REF DART SPEC. M-DELRIN-R1.250)

2) TOLERANCES ARE PER DART QSI 018 UNLESS

OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY MSCANE ALL LED

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D Pription:	Bracket				Part Number:	3/2/-7/5
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						Page 1 of 1
	FIRS	ST ARTICLE IN	SPECTION	ON CHE	CKLIST	
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Measured by:	22	Audited by:				
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Measured by:		20	Audited by:	Prototype Approval:		
	Date:	06.02/6	Date: 06.07.17		Date:	
Rev	Date	Change			Revised by	I A page and
<u>-A</u>		New Issue			KJ/RF	Approved

FIRST ARTICLE INSPECTION CHECKLIST	DART AEROS	PACE LTD				Work Order		************************************
FIRST ARTICLE INSPECTION CHECKLIST First Article	Description:					Part Number		
First Article Prototype Drawing Tolerance Actual Dimension Accept Reject Method of Inspection Comment 3.41 ± 030 ± 460 3.65 3.634 .201 ± 010 204 .400 - 700 .351 - 530 .530 .050 - 050 .050 - 032 easured by: \$A Audited by: Date: 06.02.16 Date: Prototype Approval: Date: Change	Insulaction Dwg:	Rev:					Р	age 1 of 1
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